

HiFill FR® PA6/6 GF20 FR-NR

Polyamide 66

Techmer Engineered Solutions

Message:

HiFill FR® PA6/6 GF20 FR-NR is a Polyamide 66 (Nylon 66) product filled with 23% glass fiber. It can be processed by injection molding and is available in North America. Primary characteristic: flame rated.

General Information			
Filler / Reinforcement	Glass Fiber,23% Filler by Weight		
UL File Number	E157318		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.40	%	ASTM D955
Water Absorption (24 hr)	0.70	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	111		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	125	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	6960	MPa	ASTM D790
Flexural Strength	193	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	75	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	249	°C	
1.8 MPa, Unannealed	232	°C	
CLTE - Flow	2.5E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	ASTM D257
Volume Resistivity	1.0E+15	ohms · cm	ASTM D257
Dielectric Strength ¹	17	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.800 mm, NC, BK, Colors)	V-0		UL 94
Additional Information	Nominal Value		
TPCI #	9085101		
Injection	Nominal Value	Unit	

Drying Temperature	82.2	°C
Drying Time	> 6.0	hr
Rear Temperature	254 to 277	°C
Middle Temperature	254 to 277	°C
Front Temperature	254 to 277	°C
Processing (Melt) Temp	249 to 271	°C
Mold Temperature	65.6 to 93.3	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	30 to 60	rpm

NOTE

1. Method A (Short-Time)

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